

Work Order ID 67572

Page 1

Monday, March 28, 2011 10:54:39 AM

Item ID: D206-667-103TRN

Accept



Setup Start



Revision ID:

Stop



Item Name: Crosstube Turning DetailL

Start Date: 3/28/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 4/15/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

11/03/11

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start



Stop



| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|

Draw Nbr

Revision Nbr

D206-667-143

Rev C

100

0.00



MORI SEIKI CNC LATHE LARGE

Mori Seiki

Memo

0.00

Mori Seiki CNC Lathe Large

1-Fill tube with sand & install plugs DT8534 on both ends as per Folio
FA087□2-Turn first side as per Folio FA087□3-File down transition lines
smooth. JL 11/03/11

110

0.00



QC1- Inspect dimensions to dimension sheet

QC

Memo

0.00

Quality Control

JL 11/03/11

120

0.00



MORI SEIKI CNC LATHE LARGE

Mori Seiki

Memo

0.00

Mori Seiki CNC Lathe Large

1-Turn second side as per Folio FA087□2-File down transition lines smooth.
□
3-Remove sand and plugs JL 11/03/11

| W/O: | | WORK ORDER CHANGES | | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|--|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector | |
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| | | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

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Page 2

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Required Date: 4/15/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

QC1- Inspect dimensions to dimension sheet

0.00 *SL 11/03/31*

QC

Memo

0.00

Quality Control

140

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

150

Crosstubes Chemical Conversion

0.00



HandFXtube

Memo

0.00

Hand Finishing Crosstubes

*11-4-4*

| W/O: | | WORK ORDER CHANGES | | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|--|
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Work Order ID 67572



Page 3

Monday, March 28, 2011 10:54:39 AM

Item ID: D206-667-103TRN

Accept



Setup Start



Revision ID:

Stop



Item Name: Crosstube Turning DetailL

Start Date: 3/28/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 4/15/2011 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|

160

QC3- Inspct Part Finish

0.00



QC

Memo

0.00

Quality Control

1 0 BE 10/4/04

170

Packaging

0.00



Packaging

Memo

0.00

Packaging

Identify and stock in kanban rack ☐ Location: 46

DP

11-4-4

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/4/5

11-04-4
Q

| W/O: | | WORK ORDER CHANGES | | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|--|
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NOTE: Date & initial all entries

Picklist Print

Monday, March 28, 2011 10:54:45 AM

Page 1

Work Order ID: 67572



Parent Item: D206-667-103TRN



Parent Item Name: Crosstube Turning DetailL


Start Date: 3/28/2011

Required Date: 4/15/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A 08-03-06 new issue DD verified by:ec
IPP Rev B 08.04.02 removed polish EC verified by DD

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Qty per Kit | Total Qty | Qty Issued | Date Issued | Status |
|---------------------------------------------------------------------------------------------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|
| D6002-115  Crosstube Material | | Manufactured | No | | | 110 | Each | 34.0000 | 1 | 1 | | SL 11/03/30 | |

Location

Loc Qty

Loc Code

LG

34

34684

1

34776

33

1

| W/O: | | WORK ORDER CHANGES | | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|--|
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NOTE: Date & initial all entries

| | |
|--------------------------------------------------------|-----------------------------------------|
| DART AEROSPACE LTD | Work Order: <u>117572</u> |
| Description: Crosstube Assembly (206L High Fwd) | Part Number: D206-667-143 |
| Inspection Dwg: D206-667-143 Rev: C | Page 1 of 1 |

FIRST ARTICLE INSPECTION CHECKLIST

| Inspection Sheet Drawing Dimension | Tolerance | Actual Dimension | Accept | Reject | Method of Inspection | Comments |
|---------------------------------------|-------------|---------------------|--------|--------|-------------------------|------------|
| SIDE A | 2.240 | +0.005/-0.000 | 2.245 | / | | mic CMC-04 |
| | 1.982 | +0.005/-0.000 | 1.984 | / | | vern J13 |
| | 2.019 | +0.005/-0.000 | 2.023 | / | | mic CMC-04 |
| | 2.058 | +0.005/-0.000 | 2.063 | / | | |
| | 2.097 | +0.005/-0.000 | 2.101 | / | | |
| | 2.136 | +0.005/-0.000 | 2.138 | / | | |
| | 2.176 | +0.005/-0.000 | 2.180 | / | | |
| | 2.201 | +0.005/-0.000 | 2.205 | / | | |
| | | | | | | |
| | 0.125 | +/-0.010 | .125 | / | | vern J13 |
| | 0.400 x 30° | +/-0.010 | .400 | / | | |
| | R0.063 | +/-0.010 | .063 | / | | R-G |
| | R0.500 | +/-0.010 | .500 | / | | R-G |
| | 4.438 | +/-0.030 | 4.445 | / | | |
| | | | | | | |
| SIDE B | 104.98 | +/-0.020 | 104.98 | / | | m-tape |
| | 2.240 | +0.005/-0.000 | 2.244 | / | | |
| | 1.982 | +0.005/-0.000 | 1.985 | / | | |
| | 2.019 | +0.005/-0.000 | 2.024 | / | | |
| | 2.058 | +0.005/-0.000 | 2.062 | / | | |
| | 2.097 | +0.005/-0.000 | 2.101 | / | | |
| | 2.136 | +0.005/-0.000 | 2.137 | / | | |
| | 2.176 | +0.005/-0.000 | 2.180 | / | | |
| | 2.201 | +0.005/-0.000 | 2.205 | / | | |
| | | | | | | |
| | 0.125 | +/-0.010 | .125 | / | | |
| | 0.400 x 30° | +/-0.010 | .400 | / | | |
| | R0.063 | +/-0.010 | .063 | / | | |
| | R0.500 | +/-0.010 | .500 | / | | |
| | 4.438 | +/-0.030 | 4.445 | / | | |
| | | | | | | |

| | | | |
|-------------------------------|---------------------------------------|------------------------------|-----|
| Measured by: <u>JK</u> | Audited by: <u>[Signature]</u> | Preliminary Approval: | N/A |
| Date: <u>11/03/31</u> | Date: <u>11/3/31</u> | Date: | N/A |

| Rev | Date | Change | Revised by | Approved |
|-----|----------|------------------------------|------------|--------------------|
| A | 04.05.06 | New Issue (P/O D206-667-103) | KJ/RF | |
| B | 06.03.09 | Dwg Rev updated | KJ/JLM | |
| C | 10.09.13 | Dwg Rev updated | KJ | <u>[Signature]</u> |

| W/O: | | WORK ORDER CHANGES | | | | | | |
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NOTE: Date & initial all entries

| Item | Qty -143 | Part Number | Description |
|------|-------------|----------------|------------------------------------------------------------------------------------------------------------|
| 1 | X | D206-667-143 | CROSSTUBE ASSEMBLY (206L HIGH FWD) |
| 2 | 1 | D6002-115 | CROSSTUBE |
| 3 | 2 | D2873-043 | NUT PLATE |
| 4 | 2 | D2873-045 | NUT PLATE |
| 5 | 2 | D2891-1 | SUPPORT |
| 6 | 4 | D3595-063-395 | RUBBER CUSHION |
| 7 | 4 | MS21920-20 | CLAMP (OR MS21920-21) |
| 8 | 14 | MS20601AD4W8 | RIVET (OR NAS9302B-4-8) |
| 9 | A/R | MAGNOBOND 6398 | ROCKWELL SPECIFICATION RBO-120-023 ADHESIVE (TEXTRON/BELL SPEC. 299-947-100, TYPE II, CLASS 2 ADHESIVE) |

GENERAL NOTES:

- 1) MATERIAL: MANUFACTURED FROM D6002-115
FINISHED LENGTH = 104.98±0.020
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
PRIME INSIDE AND OUTSIDE PER DART QSI 005 4.2
PAINT OUTSIDE PER DART QSI 005 4.2
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED.
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX.
- 6) IDENTIFICATION: SCRIBE DART PART NUMBER "D206-667-143" AND BATCH NUMBER ON INSIDE OF CUFF USING VIBRATING STYLUS.
- 7) WEIGHT: 15.5 lbs
- 8) PART IS SYMMETRIC ABOUT CENTERLINE.
- 9) RUN CUTTER OFF PART WHERE INDICATED. BLEND OUT EDGE LONGITUDINALLY, TRANSITION SHOULD BE SMOOTH.
- 10) BEND PROGRESSIVELY WITH A MINIMUM OF 10 PASSES. MAXIMUM TUBE FLATTENING DUE TO BENDING IS 6% BASED ON O.D.
- 11) LIQUID PENETRANT INSPECT OUTSIDE SURFACE OF CROSSTUBE PER QSI 038.
- 12) INSTALL D2891-1 SUPPORT USING 0.03" TO 0.06" THICK LAYER OF MAGNOBOND 6398 PER QSI 015. LET CURE FOR 12 HOURS AFTER INSTALLATION AND PRIOR TO PACKAGING.
- 13) INSTALL MS21920-20 CLAMPS (OR -21) WITH D3595-063-395 RUBBER CUSHIONS TO SECURE THE D2891-1 SUPPORT ON TOP SIDE OF THE CROSSTUBE. ENSURE CLAMP MECHANISMS ARE LOCATED ON CROSSTUBE SUPPORTS.
- 14) EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS, OR DENTS. DEFECTS UP TO 0.005" MAY BE BLENDED OUT LONGITUDINALLY. CIRCUMFERENTIAL GRIND MARKS ARE UNACCEPTABLE.
- 15) TORQUE CLAMPS 80 TO 100 IN-LB. ENSURE AT LEAST 1.5 THREADS ARE SHOWING IN SAFETY AND THAT NUT HAS NOT BOTTOMED-OUT AFTER TORQUING.

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 47572
R11-03-28

RELEASED
28/11/11

| | | | |
|---------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|----|----------|
| C | REVISE GENERAL NOTES/PART LIST (ZN D7-1); REORGANIZED VIEWS AND REFORMATTED DRAWING TO CURRENT STANDARDS. D3595-063-395 WAS D2856-400-694 (ZN D6-2 & A5-2); REMOVED REF. & ADD TOLERANCE (ZN D3-3, C4-3, C5-3); RELOCATED FLAG #6 (ZN A8-3) PER NCR 210; MOVED TURNING DETAIL & UPDATED TOLERANCE TO SHEET 4. | RF | 08.11.06 |
| B | ADD HOLES AND NUT PLATES FOR COMPATABILITY WITH BHT/AA SKUDTUBES | PH | 05.07.26 |
| A | NEW ISSUE | CP | 00.11.17 |
| REV. | DESCRIPTION | BY | DATE |
| DESIGN | 92 | | |
| DRAWN | RF | | |
| CHECKED | 92 | | |
| MFG. APPR. | 92 | | |
| APPROVED | 92 | | |
| DE APPR. | 92 | | |
| DATE | 08.11.06 | | |
| DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D206-667-143 REV. C SHEET 1 OF 4 TITLE CROSSTUBE ASS'Y (206L HIGH FWD) SCALE NTS COPYRIGHT © 2006 BY DART AEROSPACE LTD. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD. | | | |

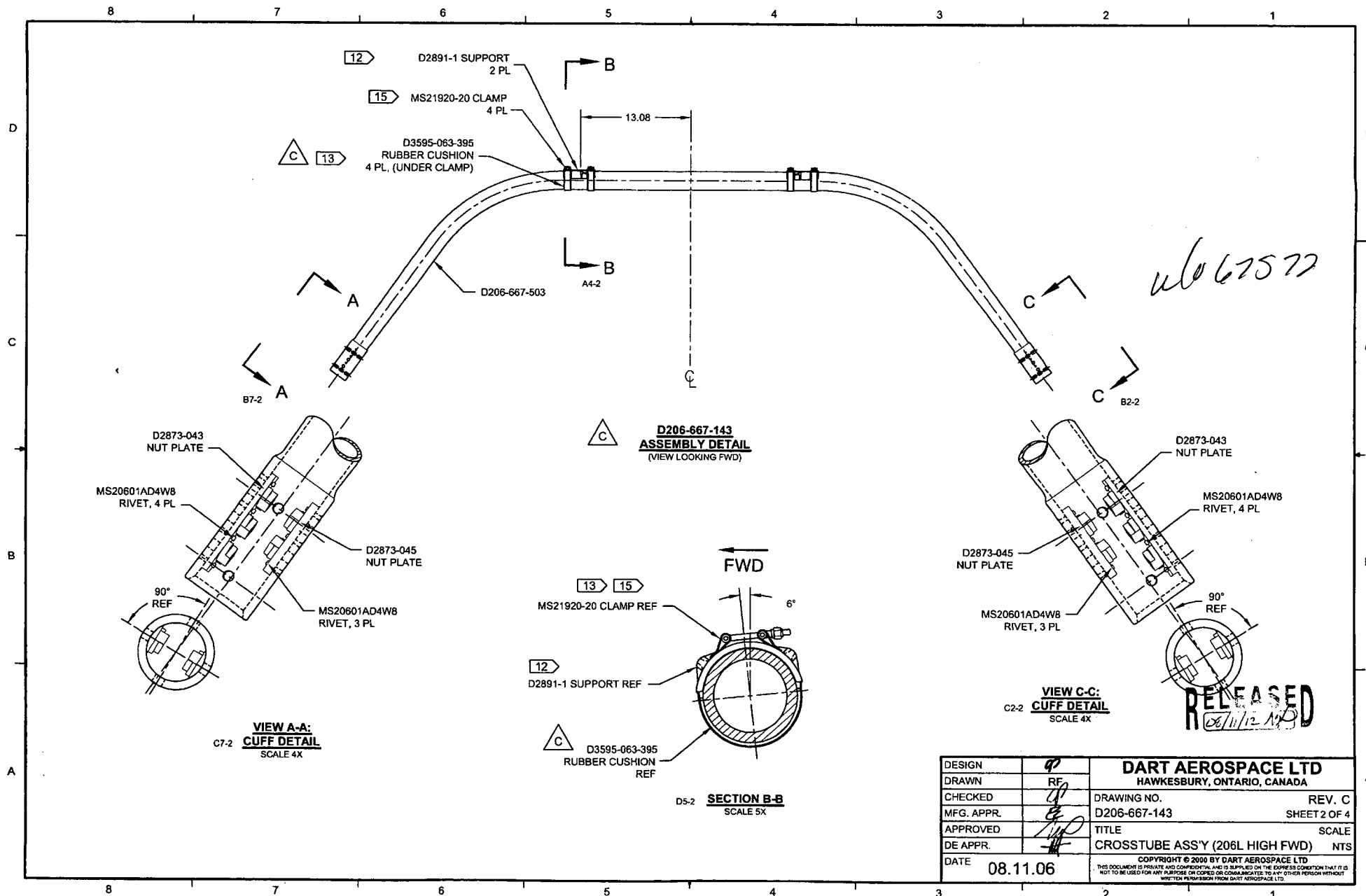
| W/O: | | WORK ORDER CHANGES | | | | | | |
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NOTE: Date & initial all entries



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|-------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|----------|----------------------------------------|--------------|
| DESIGN | 7 | DART AEROSPACE LTD | |
| DRAWN | RF | HAWKESBURY, ONTARIO, CANADA | |
| CHECKED | 7 | DRAWING NO. | REV. C |
| MFG. APPR. | 7 | D206-667-143 | SHEET 2 OF 4 |
| APPROVED | 7 | TITLE | SCALE |
| DE APPR. | 7 | CROSSTUBE ASS'Y (206L HIGH FWD) | NTS |
| DATE | 08.11.06 | COPYRIGHT © 2006 BY DART AEROSPACE LTD | |
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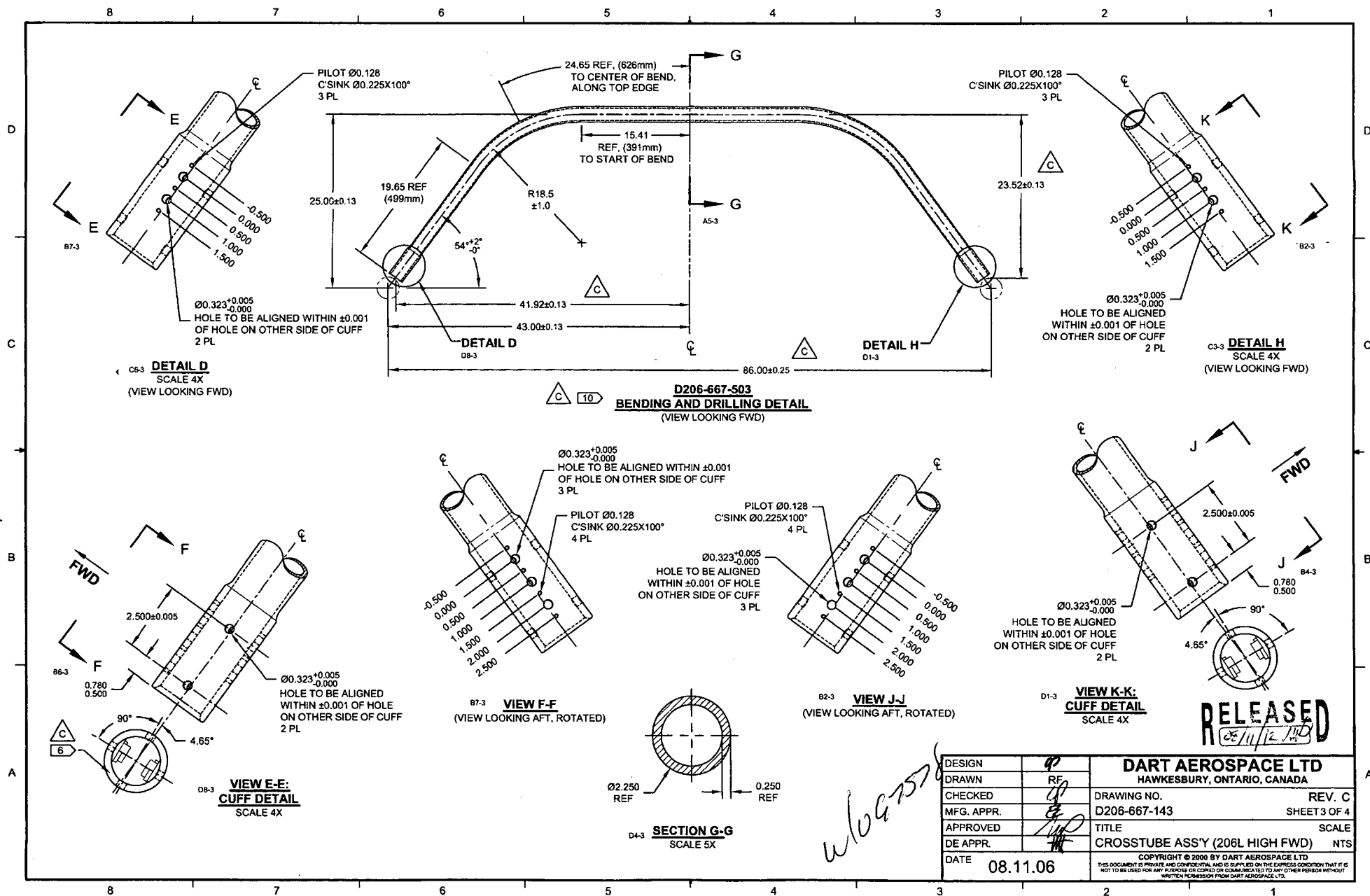
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| DESIGN | 47 | DART AEROSPACE LTD | |
| DRAWN | RF | HAWKESBURY, ONTARIO, CANADA | |
| CHECKED | 47 | DRAWING NO. | REV. C |
| MFG. APPR. | 47 | D206-667-143 | SHEET 3 OF 4 |
| APPROVED | 47 | TITLE | SCALE |
| DE APPR. | 47 | CROSSTUBE ASS'Y (206L HIGH FWD) | NTS |
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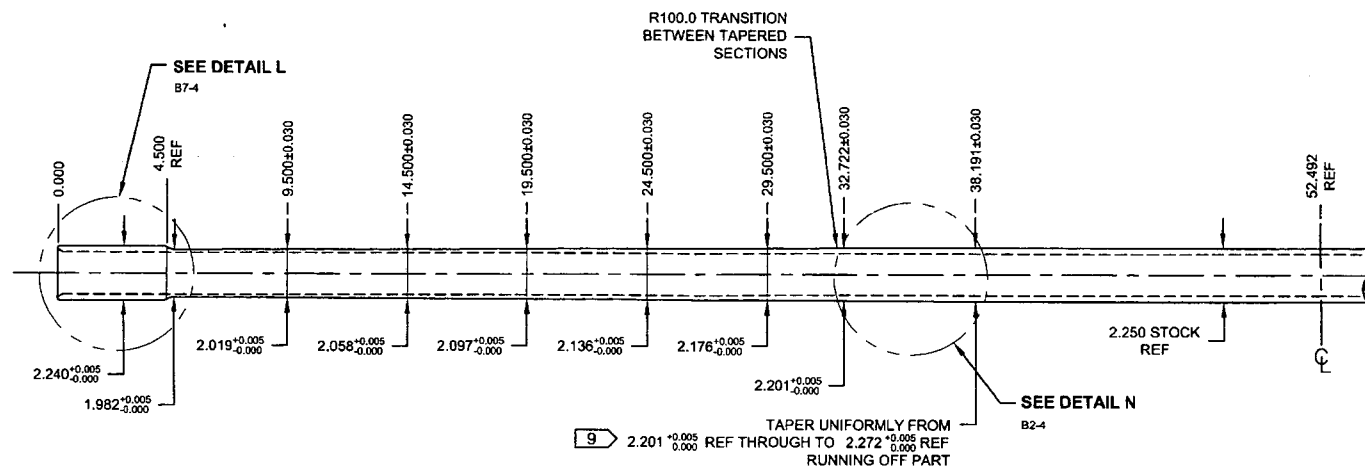
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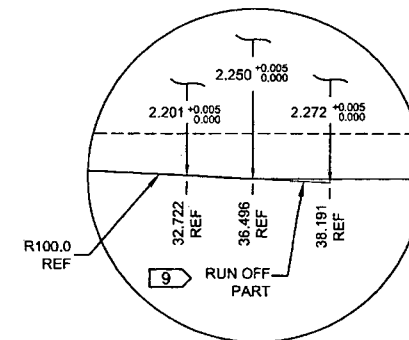
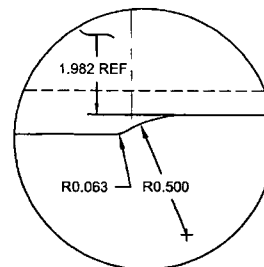
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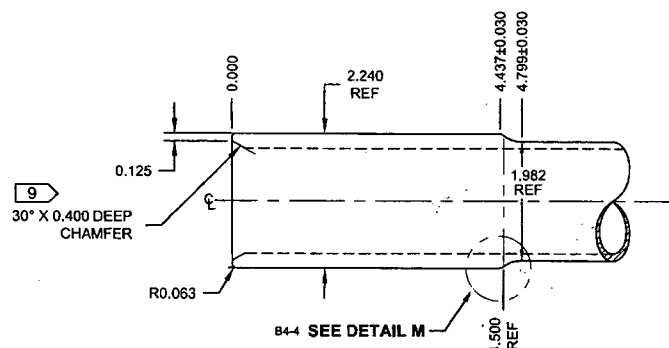
206-1572

TURNING DETAIL



DETAIL N:
C4-4 TAPER RUN-OFF
NOT TO SCALE

RELEASED



DETAIL L:
D7-4 CROSSTUBE CUFF
NOT TO SCALE

DETAIL M:
A6-4 CUFF TRANSITION
NOT TO SCALE

| | | | |
|--------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|----------|----------------------------------------|--------------|
| DESIGN | 9 | DART AEROSPACE LTD | |
| DRAWN | RF | HAWKESBURY, ONTARIO, CANADA | |
| CHECKED | RF | DRAWING NO. | REV. C |
| MFG. APPR. | RF | D206-667-143 | SHEET 4 OF 4 |
| APPROVED | RF | TITLE | SCALE |
| DE APPR. | RF | CROSSTUBE ASS'Y (206L HIGH FWD) NTS | |
| DATE | 08.11.06 | COPYRIGHT © 2006 BY DART AEROSPACE LTD | |
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| | | | Initial Chief Eng | Action Description Chief Eng | | | | Sign & Date |
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NOTE: Date & initial all entries